Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3793-3
Job Sheet 187159

Part No: D3793-3
Part Name: Wearplate Aft
Part Weight: 0 lbs
Job Qty: ~~6 ea~~ 13
Status: New
Priority: Medium
Job Created: 11/28/18
Job Tracking No:
Due Date: 12/21/18
Created By: Jesse White
Type: Stock
Description:

Note: DWG D3793 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC IPP REV:C 18.11.09 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	**Waterjet - Flow - 1**	6 pcs		12/21/18	0.00	0.79	Waterjet - Flow		DA 18/11/28
110	**QC**	6 pcs		12/21/18	0.00	0.00	QC2 Waterjet-2		DA 18/11/28 DAS
120	**QC**	6 pcs		12/21/18	0.00	0.00	QC8-3		DEC 04 2018 68
130	**Brake NC**	6 pcs		12/21/18	0.15	0.19	Brake NC 1		SD 9889
140	**QC**	6 pcs		12/21/18	0.00	0.00	QC5		DEC 05 2018 68
150	**Spray Paint - 2 - B4B**	6 pcs		12/21/18	0.00	0.60	Spray Paint - 1 - B4B		AB 18-12-6 9-89
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		DAS
160	**QC**	6 pcs		12/21/18	0.00	0.00	QC3		DEC 29 2018 68
170	**Packaging**	6 pcs		12/21/18	0.00	0.00	Packaging3-1 FP002		BE 18-12-~~29~~-89 (13)
180	**QC21-SA**	6 Ea		12/21/18	0.00	0.00	QC21		JAN 02 2019 21 9889

Part Op Descriptions:
100 - 1-Cut as per Dwg D3793 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
130 - 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs
150 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI
BATCH: 138799 EX 9/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	7.6968 sf (1.2828 ea)	100-Waterjet - Flow - 1	SO910402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	8	135	0

Part Specifications

Specifications could not be found.

Plex 11/28/18 11:06 AM dart.white.jesse

Entered: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled
☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function
☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up
☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☐ Part Lost/Missing
☐ Misread

Other/Details:

DART AEROSPACE LTD	Work Order:	
Description: Wearshoe DAS 10 9-89	Part Number:	D3793-3
Inspection Dwg: D3793 Rev: A / B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	Ø.187	1			
0.300 ~~x 0.300~~	+/-0.010	.299	1			
1.89 ~~1.885~~	+/-0.010	1.8	1			
4.389	+/-0.010	4.389	1			
6.55 ~~6.547~~	+/-0.010	6.55	1			
6.00	+/-0.030	6.00	1			
6.75	+/-0.030	6.75	1			
2.000	+/-0.010	2.00	1			
4.750	+/-0.010	4.75	1			
9.500	+/-0.010	9.50	1			DAS DEC 2 68 2018 9-89
14.250	+/-0.010	14.75	1			
17.750	+/-0.010	17.75	1			
26.735	+/-0.010	26.74	1			
Ø0.531 x 0.780	+0.008/-0.001	Ø.530x.777	1			
.330	+/- .010	.329	1			

Measured by:	DL	Audited by:		Prototype Approval:	N/A
Date:	18/11/28	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :

Sequence #:

QTY Affected :

MRB (QSI042)

Descri

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Container No: S132951
Part: D3793 – 3
Job No: 187159
Serial No/Batch: S132951
Revision: B
Inspector:
Exp Date:
Instructions: Various STC's
Date: 11/28/18

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CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
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Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Loss/Surge ☐
rogram ☐
Direction ☐
g Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Marks/Chatter ☐
Mislabeled ☐
Drill Holes ☐
Fit/Function ☐

Other/Details:

DART AEROSPACE LTD		Work Order:	187159
Description: Wear Shoe		Part Number:	D3793-3
Inspection Dwg: D3793	Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.188	-.001 +.005	Ø.187	1		V.D. - 02	
Ø.531	-.001 +.005	Ø.530	1			
.300	+/- .010	.299	1			
.330	+/- .010	.329	1			
.780	+/- .010	.777	1			
1.89	+/- .030	1.89	1			
4.389	+/- .010	4.389	1			
6.55	+/- .030	6.55	1			
6.00	+/- .030	6.00	1			
6.75	+/- .030	6.75	1			
2.00	+/- .030	2.00	1			
4.75	+/- .030	4.75	1			
9.50	+/- .030	9.50	1			
14.75	+/- .030	14.75	1			
17.75	+/- .030	17.75	1			
26.74	+/- .030	26.74	1			
.034	+/- .010	.035	1			

Measured by:		Checked by:		QC Inspector:	
Date:	15/11/26	Date:		Date:	

Engineering Approval: (If necessary)		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	